

Date: Monday, 7/9/2007 12:46:58 PM
 User: Kim Johnston

Process Sheet

30

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B STEP ASSEMBLY RH
 Job Number : 33412
 Estimate Number : 11115
 P.O. Number : N/A Part Number : D206628012
 This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 32980 Material : N/A
 Due Date : 7/27/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : 07.07.09
 Comment : Est Rev. B As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



RS 07.07.09

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-012 CHG 002

2.0 33412A 206B STEP ASSY, RH



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, RH

D2721-042 B 33412A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27311 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|-------|
| 2 | D2731-1 | Mounting Lug | 39112 |

5.0 D27317 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|--------|
| 2 | D2731-7 | Mounting Lug | 333420 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:
 QA: N/C Closed: Date:

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 33412

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total: 3.5123 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip

B34293-

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total: 1.6380 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.25" Abrasion Strip

B34293-

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-041 LUG ASS,Y

B30997-

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-043 LUG ASS,Y

B33225-

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M104072-

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-11A Bolt

M102280-

Epo 7/19/25(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 7/26/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 33412

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M105143

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M104746

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M104683

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-012

Location:

PPP Rev:

E

7/9/26

scf

(3X)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

H207/26

Job Completion



U 8/10/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:05 PM
User: Kim Johnston

Process Sheet

30

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B STEP ASSY, RH
Job Number : 33412A
Estimate Number : 11699
P.O. Number : N/A Part Number : D2721042
This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : D2721 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
Previous Run : 32980A Material : N/A
Written By : Due Date : 7/27/2007 Qty: 3 Um: Each
Checked & Approved By : *[Signature]*
Comment : Est Rev: F As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

| Qty | Part # | Description | Batch: |
|-----|------------|-------------|--------|
| 1 | D2622-120C | Extrusion | B34016 |

Check Material for any Dents or Defects

Re-work *SE 07-09-18* 3
Q.M *07.09.18* 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-2 using D2622 extrusion as per Dwg D2721
Deburr and bevel ends for welding

Re-work *SE 07-09-18* 3
Q.M *07.09.18* 3
Re-work *SE 07-09-18* 3
Q.M *07.09.18* 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D2734 | End Cap | B33861 |

Re-work *SE 07-08-19* 3

4.0 D34611 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

206 Step Lug

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3461-1 | Plate | B33070 |

Re-work *SE 07-08-19* 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 33412A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3461-3 Plate

333071

SE 07-08-19 3

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3461-5 Plate

333072 = 2

333862 = 1

SE 07-08-19 3

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3461-7 Plate

333073 = 2

333863 = 1

SE 07-08-19 3

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch: M103794

Grind end cap welds flush

SE 07-08-19 3

9.1 07.09.20

3

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.09.20 (3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 33412A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/20 HB RH

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.09.20 3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/09/20

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch:

m/03794

RG

Grind End Cap Welds Flush

Q.M

07.09.20

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/21 (3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/21 (24X3)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

BR

07-09-24 (3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/09/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:47:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 33412A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

POWDER COATING

POWDER COATING



M105068



3X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/09/24

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/09/24 (3)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M105386



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

FL 07/09/24 (3)

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/9/25 59

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 33412

7/9/25 59

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/26 (3)

Job Completion



U 07-09-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

RELEASED

| | | | | | |
|---------------|---------------|---|--|--------------|--|
| DESIGN | | DRAWING NO. | | REV. C | |
| PH | PH | D2721 | | SHEET 1 OF 1 | |
| CHECKED | APPROVED | DATE | | SCALE | |
| 11 | 11 | 05.09.19 | | NTS | |
| A | 97.12.04 | NEW ISSUE | | | |
| B | 98.10.19 | 79° WAS 80° UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0 | | | |
| C | 05.09.19 | RE-DESIGN, ADD D3461-1/-3/-5/-7 | | | |

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

| QTY - 041 | QTY - 042 | PART NUMBER | DESCRIPTION |
|--------------|--------------|-------------|------------------|
| X | | D2721-041 | LH STEP ASSEMBLY |
| | X | D2721-042 | RH STEP ASSEMBLY |
| 1 | 1 | D2622-078 | EXTRUSION |
| 2 | 2 | D2734 | END PLATE |
| 1 | 1 | D3461-1 | PLATE |
| 1 | 1 | D3461-3 | PLATE |
| 1 | 1 | D3461-5 | PLATE |
| 1 | 1 | D3461-7 | PLATE |

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL B

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